

Date: Wednesday, 06/08/2008 2:06:58 PM  
 User: Julie Lecocq

## Process Sheet

|                       |   |                  |                              |
|-----------------------|---|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services         | Drawing Name     | : ACCESS PANEL ASS'Y         |
| Job Number            | : 41034                                       |                  |                              |
| Estimate Number       | : 13541                                       |                  |                              |
| P.O. Number           | :   | Part Number      | : D3307041                   |
| This Issue            | : 06/08/2008 S.O. No. :                       | Drawing Number   | : D3307 REV. A               |
| Prsht Rev.            | : NC  | Project Number   | : N/A                        |
| First Issue           | : // Type : SMALL /MED FAB                    | Drawing Revision | : A                          |
| Previous Run          | :   | Material         | :                            |
| Written By            | :   | Due Date         | : 25/08/2008 Qty: 6 Um: Each |
| Checked & Approved By | : <u>JLD 08.8.06</u>                          |                  |                              |
| Comment               | : Est: A 08.08.05 New issue EC verified by:DD |                  |                              |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S22GA | 304/316 .032 Sheet |
|-----|-----------|--------------------|



25

MAT NOT PULLED



Comment: Qty.: 0.2600 sf(s)/Unit Total: 1.5600 sf(s)

304/316 .032 Sheet

batch: 169023 HB 8-8-26

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut D3307-1 as per Dwg D3307

Dwg Rev: AProg Rev: AHB 8-8-26

⑦

2-Deburr if necessary

HB 8-8-26

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

HB 8-8-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

08/08/27 (7)

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

bend as per dwg D3307

SB 08/09/03

⑦

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:58 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSY

Job Number: 41034

Part Number: D3307041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D33073

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Gasket B46057

SB 08/09/03 (7)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond gasket as per dwg D3307

CP 08/09/11 (7)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/11 (47)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 83

8/9/11

(71)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11 (8)

Job Completion



W 08.29.11

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

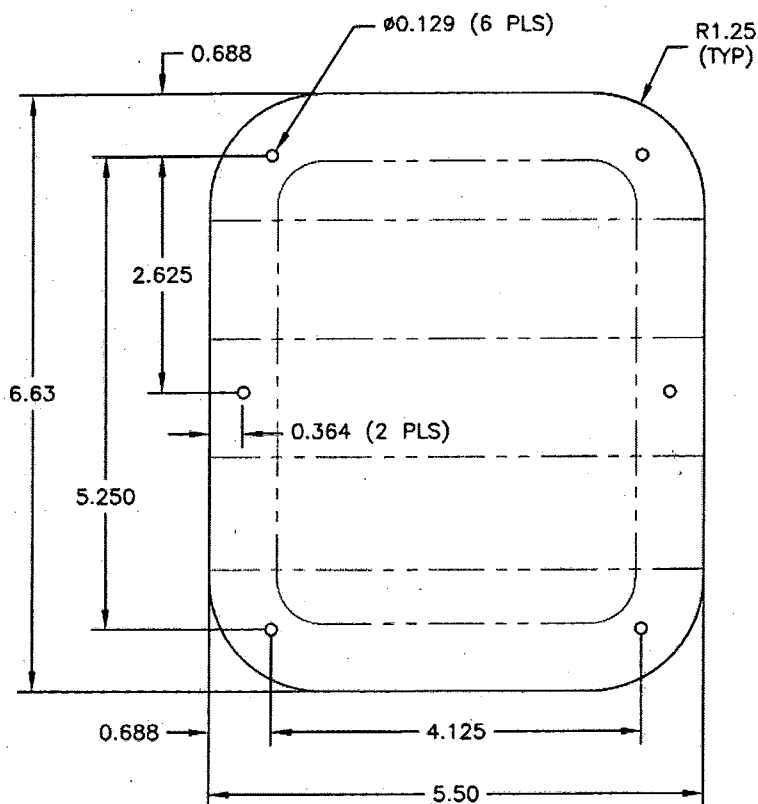
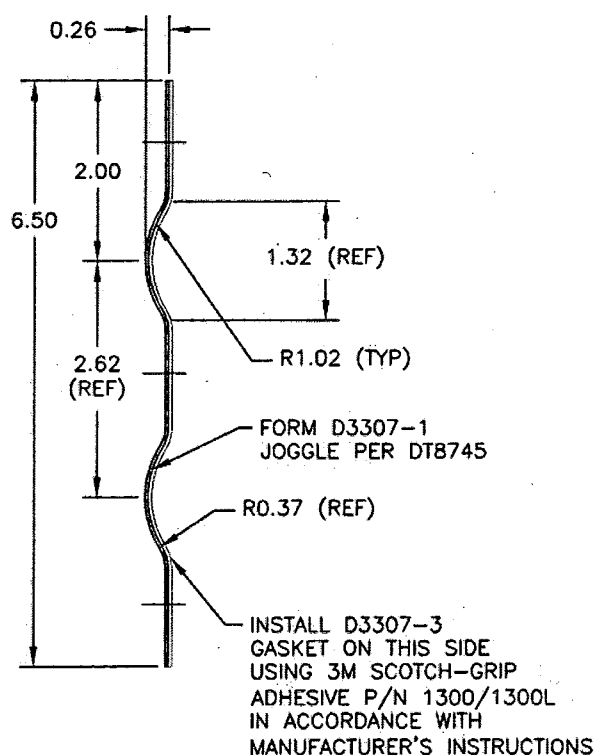
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART****RELEASED**  
05.01.18

|                        |                         |   |                        |
|------------------------|-------------------------|---|------------------------|
| DESIGN<br>[Signature]  | DRAWN BY<br>[Signature] | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3307                              | REV. A<br>SHEET 1 OF 2 |
| DATE<br>04.09.23       |                         | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:2           |
| A                      | 04.09.23                | NEW ISSUE   |                        |

**D3307-1 PANEL FLAT PATTERN****D3307-041 BEND DETAIL**  
IDENTIFY WITH P/N & B/N  
USING FINE POINT  
PERMANENT MARKER**D3307-1 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

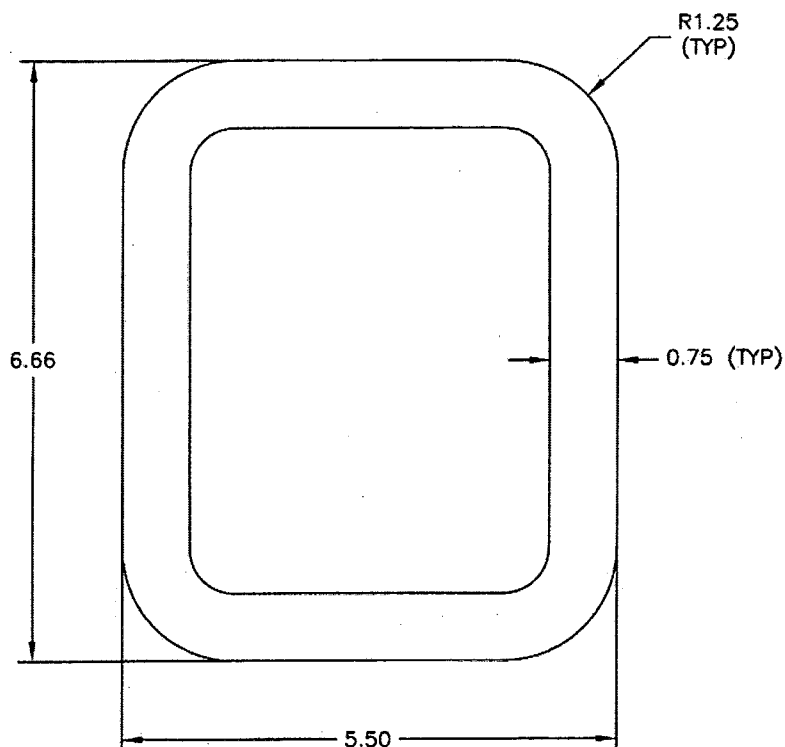
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**DART**

|                        |                         |   |                        |
|------------------------|-------------------------|---|------------------------|
| DESIGN<br>RF           | DRAWN BY<br>RF          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3307                              | REV. A<br>SHEET 2 OF 2 |
| DATE<br>04.09.23       |                         | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:2           |

**RELEASED**  
05.01.18 [Signature]**D3307-3 GASKET****D3307-3 NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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